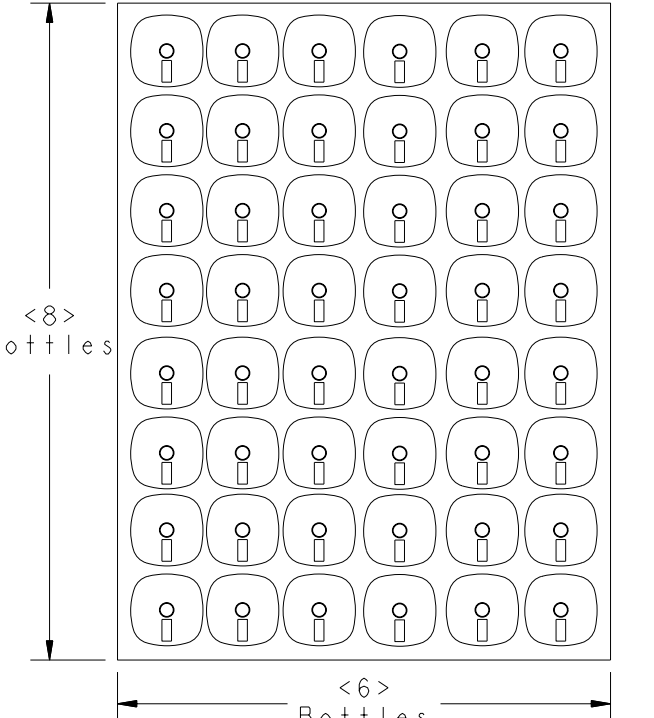


PACKAGING INFORMATION



1. Bottles are to be shipped 6W X 8D with handles inline with depth direction.
2. Bagged in a 2 mil low density polyethylene clear sealed bag.
3. Bottles packaged with no dust covers or caps.
4. No cardboard material is allowed within the bag.
5. Each bag must be marked with the run number as a minimum.

REVISIONS						
REV.	DESCRIPTION	GCO. NO.	DRWN BY	ENGR BY	APPR	DATE
A	CONVERT DRAWING TO PRO/E		SRA	SRA		03-21-07

NOTE 2

XX 75227-510

VENDOR NAME HERE (OPTIONAL)
 HDPE

BOTTOM VIEW

SCALE 2.000

THREAD DATA:
 NECK FINISH REF: SP-400-48
 ALL PURPOSE THREAD
 THREADS PER INCH: 6
 PITCH: .167
 480° TURN OF THREAD
 START POINT ORIENTATION IS CRITICAL

SECTION C-C
 SCALE 1.000

NOTES:

1. Wall thickness .017 minimum.
2. Cavity number location. Cavity I.D. is required.
3. Level fill 132.9 oz. +/- 1-1/2 oz.
4. Gram weight 130 grams +/- 5 grams.
5. Slanted ream spec. 0.023 across lip of bottle maximum.
6. Lettering to be 1/4" height Helvetica 0.015 deep.
7. Mold flash is allowed only as follows:
 - a. Cap sealing lip; NONE.
 - b. Handle; .010 max.
 - c. Threads; .010 max.
 - d. All other areas; .025 max.
8. Cleanliness:
 - a. No loose or imbedded metal particulates.
 - b. No molded in particulates >0.008 in diameter. Smaller particulate not to exceed 2 parts per panel.
 - c. No mold release, dust particulate, any other surface contaminate.
9. The bottle lip will be free of defects that cause leakage after heat sealing cap. (fractures, cuts, gouges)
10. Land seal saddle dip 0.015 maximum. (maximum dip seal area on bottle lip)
11. Bottle must not leak.
12. reserves the right to request any ongoing statistical process control data and/or inspection data concerning this product. All manufacturing data must be maintained for a minimum of (36) months from date of manufacture.
13. Any process or material changes by the vendor that will affect form, fit or function must be approved in writing by prior to manufacturing the product. This may require bottle requalification by
14. Flame treat bottle neck seal area.
15. Neck dimensions 1.867 max / 1.843 min ("T") and 1.773 max / 1.749 min ("E") must be in tolerance measured in two directions, 90° apart.
16. Neck finish ovality to be 0.035 maximum.
17. Each shipment must be accompanied by a certificate of analysis. The certificate shall include, at a minimum, the following information: Bottle height, Minimum wall thickness, Gram weight, Resin material, Bottle manufacturer lot number.
18. Manufacturer will maintain lot traceability for resin.

INSPECTION CRITERIA:

1. Maintain constant appearance throughout bottle per sample. View part 18" away with unaided eye in light.
2. Leak test all bottles using a .2 micron or smaller filter using compressed air at 1-3 PSI.
3. .430/.400 dimension is measured to intersection of 1.867 dia. and 10° flange.
4. All test bottles must be air pressure tested at a minimum of 10# of air pressure to assure that no leaks, cracks, or splits are evident.
5. All test bottles must be filled with water, capped, and drop tested from a minimum height of 3 feet, to check for failures.
6. Water spots that are not detected from a distance of 24" away from sight, with unaided eye, with a 5 second inspection time, will be acceptable.

* These are critical dimensions.

UNSPECIFIED LIMIT OF TOLERANCES		MATERIAL: NON-PIGMENTED NATURAL HDPE RESIN: LR-7340-01		HEAT TREAT:	FINISH:
.X	± .015	CONCENTRICITY	.010		SPI 5-6/ETCHED
.XX	± .010	L.25/11R			
.XXX	± .003	STRAIGHTNESS AND OR FLATNESS			
X.X	± .4	.005/IN (.127/25)			
X.XX	± .2	THREADS-EXT. -2A			
X.XX	± .08	ANGLE±1/2° BEND±2°			

ENGR:	DRWN:	APP:	TITLE:
SRA	SRA		BOTTLE, SCALLOPED ONE GALLON, SQUARE
DATE:	SCALE:		
03-21-07	1.000		

SIZE	DRW. NO.	REV.
D	22234	A
SHT	1 OF 1	

MOLD TO BE ETCHED ON ALL 4 SIDES TO A DEPTH OF .003-.005. PATTERN TO BE #TR-204

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